

Tuesday, 22/07/2008 8:49:18 AM
Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ADJUSTABLE ATTACHMENT ARM ASSY
Job Number	: 40693	Part Number	: PB674300159
Estimate Number	: 13479	Drawing Number	: B6743001 P.14
P.O. Number	:	Project Number	: N/A
This Issue	: 22/07/2008 S.O. No. :	Drawing Revision	: B1
Prsht Rev.	: NC	Material	:
First Issue	: 11 Type : LARGE FAB ASSY	Due Date	: 29/07/2008
Previous Run	:	Qty:	Um: Each
Written By	:		
Checked & Approved By	: <u>mf 08-07-23</u>		
Comment	: Est Rev:A 08-07-18 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0 PB6743001113 Square Tubing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Square Tubing

batch: B40599 X3 SP B10537 X1 (4x)

2.0 PB6743001119 End Cap Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

End Cap Clevis

batch: B40016 V SP 08-07-31 (4x)

3.0 PB6743001117 Hook Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Hook Plate

batch: B40015 V SP 08-07-31 (4x)

4.0 PB6743001115 Tube End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Tube End Plate

batch: B40014 V SP 08-07-31 (4x)

5.0 PB6743001271 Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Doubler

batch: B40058 V SP 08-08-6 (8x)

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Drawing Name: ADJUSTABLE ATTACHMENT ARM ASSY

Job Number: 40693

Part Number: PB674300159

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

M6061T6T1750W065

6061T6 RDTUBE 1.750 X 0.65W



Comment: Qty.: 0.1575 f(s)/Unit Total: 0.7875 f(s)

6061T6 RDTUBE 1.750 X 0.65W

batch: M18188

SP 08-07-31 - 08-08-06

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: 1- to make -105 take M6061T6 tube and fabricate to fit contour of cut

2- Weld -105 to -113 as per dwg and grind weld flush

3- weld 119, -117 and -115 to -113 as per dwg PB67-43001

4- pick two -271 and weld one on each side of tubing but only one need to be trim to fit on -113 as per dwg

PB67-43001

NOT READ THIS BATCH ONLY TO AVOID CRACKING

SP 08-08-01 (4X)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

D 08-08-01 (4)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/07 (4)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-1

08/08/08

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:15
320 °F
9:45

M-1

08/08/08

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-08

(4X)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADJUSTABLE ATTACHMENT ARM ASSY

Job Number: 40693

Part Number: PB674300159

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PB6743001267

PB67-43001-267



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

PB67-43001-267

batch: 340095

14.0

PB6743001121

Square Sleeve



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Square Sleeve

batch: 340612

15.0

BSP43

RIVET



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

RIVET

batch: 17890

16.0

MS17984C413

PIN, QUICK RELEASE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

PIN, QUICK RELEASE

batch: 108826

17.0

30345T21

LANYARD



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

LANYARD

batch: 102812

18.0

MS27039122

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

SCREW

batch: 18057

19.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

batch: 108814

for 08-08-26
was done only re splik 08-08-26

08-08-26

08-08-26

08-08-26

08-08-26

08-08-26

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADJUSTABLE ATTACHMENT ARM ASSY

Job Number: 40693

Part Number: PB674300159

Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0	NAS1149F0332P	WASHER
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

WASHER

batch: 18057

08-08-08

21.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- take -267 and transfer drill holes in -113 as per dwg PB67-43001

2- deburr and rivet -267 to -113 as per dwg

3- assemble rest of parts as per dwg PB67-43001

08-08-08

22.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

08/10/23

40

23.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stamp

Location: 1

08-10-23

08/10/23

24.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08-10-23

